

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: gftDate: 14/05/16QA Closed: gftDate: 14/5/19

Work Order: <u>117575</u> Part No. <u>DS046-047</u> NCR No. <u>14-3833</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/> Composite <input type="checkbox"/> Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>	<u>14.04.29</u>	<u>110</u>	<u>1</u>	<u>DS054-1 was welded on opposite side</u> <u>RC. OPERATOR/ Wt Paying attention to Dwg</u>	<u>DAS 16 9-89</u> <u>Q52042 14/05/19</u> <u>DAS 22 9-89</u> <u>14.05.02</u>	<u>cut off DS054-1 and replace with new one DS054-1 → B116625</u> <u>ACCEPTABLE DEVIATION. CONDUIT IS NOT STRUCTURAL ONLY USED FOR PATTERN WIRES.</u>	<u>EL</u> <u>14.4.29</u>	<u>DAS 9 9-89</u> <u>14.04.29</u>	<u>DAS 16 9-89</u> <u>Q52042 14/5/12</u>		
Equip/Tooling <input type="checkbox"/>											
Operator <input checked="" type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <u>Drawing was not Paid attention too</u>

Work Order ID 117575

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117575

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Item ID:	D5046-047	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop		*NS2*
Item Name:	Co-Pilot Collective Head Assembly					
Start Date:	4/28/14	Start Qty:	3.00			
Required Date:	4/29/14	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>24023</u> Black Anodize as per Dwg D5046 C OF C REQUIRED								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging	C OF C REQUIRED								
160	QC6- Inspect dimensions to drawing	0.00							
160									
QC	Memo	0.00							
Quality Control									

CL14104130(3)

1414/10/2 (3)

*SMP
14/5/5*

2

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Item ID: D5046-047

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head Assembly

Start Date: 4/28/14 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 4/29/14 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170						3			FF 14-05-05
Small Fab	Memo	0.00							
Small Fab	RE-PASS HELICOIL TAP IN THREADS AND INSTALL HELI-COIL ASSEMBLY AS PER DWG, - To be assembled at Eagle all per Stan								14-05-05
180	QC5- Inspect part completeness to step on W/O	0.00							
180						3			
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: _____	0.00							
190									14/5/5 (3)
Packaging	Memo	0.00							
Packaging									

SNP
116632

DAS
27
P-89
MIS/7

Work Order ID 117575

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Item ID: D5046-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head Assembly

Start Date: 4/28/14 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 4/29/14 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MCS 14-05-08

14-05-07

Picklist Print

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Page 1

Work Order ID: 117575

117575

Parent Item: D5046-047

D5046-047

Parent Item Name: Co-Pilot Collective Head Assembly

Start Date: 4/28/14

Required Date: 4/29/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5046-7		Manufactured	No				Each	0.0000		3			
D5046-7					B116623x3				**		Q	14-4-28	
Co-Pilot Collective Head													
D5054-1		Manufactured	No				Each	4.0000		3			
D5054-1									**		Q	14-4-28	
Conduit													

Location	Loc Qty	Loc Code
ST129	4	
116625	4	
90296A108	Each	302.0000

90296A108

Heli-Coil Insert

**

14/05/05

Location	Loc Qty	Loc Code
ST391	302	
m127878	52	
m128972	250	
	Each	27.0000

MS171539

Purchased

No

MS171539

Pin

**

Location	Loc Qty	Loc Code
ST331	7	
123183	7	
ST332	20	
m128790	20	

MS 27644-3

m128936

Boring

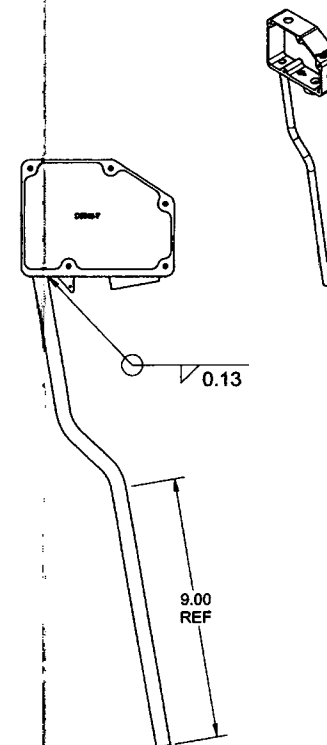
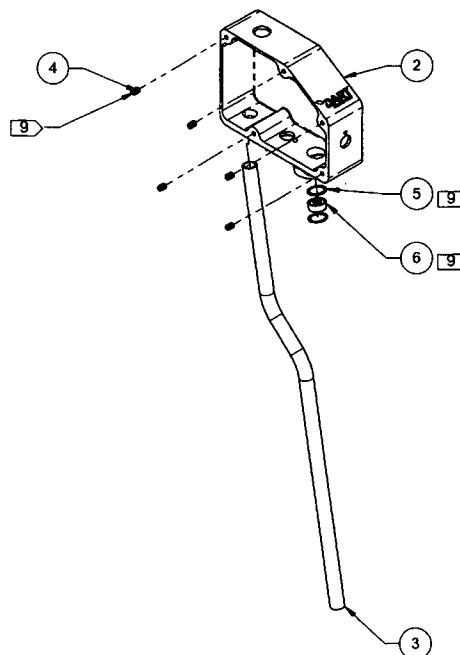
drop in kit

D5073-1 snap ring - drop ship from McMaster

(2)

DAS
30
9-89

ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5046-7	CO-PILOT COLLECTIVE HEAD
3	1	D5054-1	CONDUIT
4	5	90296A108	HELL-COIL INSERT (6-32 X 0.276)
5	2	D5073-1	SNAP RING
6	1	MS27641-3	BEARING



D5046-047 WELDING DETAIL

**D5046-047 CO-PILOT COLLECTIVE HEAD ASSEMBLY
(FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.89 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

W/O 117575

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5046	SHEET 4 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	14.01.22	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2014-04-04



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63016

Date: 02-May-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 4 PCS D5046-041 (6.25) 3 PCS D5046-047 (6.25) 8 PCS D5046-041 (6.25) 33 PCS D5049-1 (3.25) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 PRICE IS PER PIECE Job: 20140254	PO: 24023 Line:	
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>2/5/14</u> CERTIFIED SIGNATURE : <u>[Signature]</u> RECEIVER SIGNATURE : _____			